







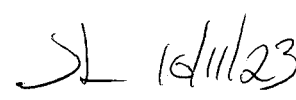


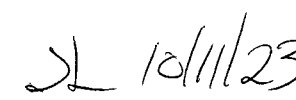
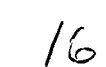
Work Order ID 62682

Wednesday, October 06, 2010 2:29:57 PM

Page 1

Item ID:	D2521	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bearpaw 205					
Start Date:	10/6/2010	Start Qty:	8.00 16	Cust Item ID:		
Required Date:	10/15/2010	Req'd Qty:	8.00	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	10/10/09	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2521	Rev J								
120		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut Blank as per D2521 blank file								
									
130		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2521 Identify as D2521 3-Deburr								
									
									
140		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
									
									

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62682

Wednesday, October 06, 2010 2:29:57 PM

Page 2

Item ID: D2521

Accept

Setup Start

Revision ID:

Stop

Item Name: Bearpaw 205

Start Date: 10/6/2010 Start Qty: 8.00

Required Date: 10/15/2010 Req'd Qty: 8.00

Cust Item ID:



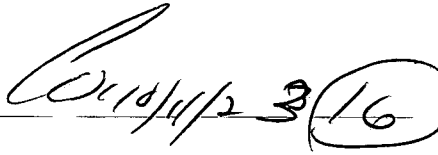

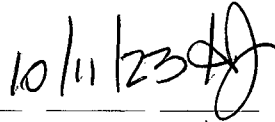
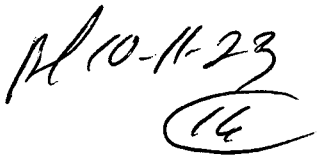
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		L.A		16	8		
160  Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00		PPP 62542					
170  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							 10-11-23 

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 06, 2010 2:30:01 PM

Page 1

Work Order ID: 62682



Parent Item: D2521



Parent Item Name: Bearpaw 205


Start Date: 10/6/2010

Required Date: 10/15/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 08-10-01 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10  UHMW 1" Black		Purchased	No				sf	194.0533	7	58.94737			



10-10-7

Location

Loc Qty

Loc Code

MAT

194.0533

113903

79.7473

114624

8.8

115325

105.506

115325 - 58.94737

115958

58.94737

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <i>62682</i>
Description: Bearpaw		Part Number: D2521
Inspection Dwg: D2521 Rev: J		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Inspection Sheet Drawing Dimension			Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dim	Min	Max					
A	0.260	0.266	<i>0.260</i>	✓		<i>vern L-3</i>	
B	0.90	0.96	<i>0.925</i>	✓		<i>"</i>	
C	0.27	0.330	<i>0.315</i>	✓		<i>"</i>	
D	0.470	0.530	<i>0.500</i>	✓		<i>"</i>	
E	21.740	21.760	<i>21.750</i>	✓		<i>m-tape</i>	
F	0.72	0.780	<i>0.750</i>	✓			
G	0.35	0.410	<i>0.380</i>	✓			
H	11.490	11.570	<i>11.500</i>	✓			
I	3.41	3.47	<i>3.430</i>	✓			
J	11.790	11.810	<i>11.800</i>	✓			
K	9.47	9.53	<i>9.50</i>	✓			
L	7.190	7.210	<i>7.200</i>	✓			
M	6.910	6.970	<i>6.94</i>	✓			
N	44.47	44.530	<i>44.50</i>	✓		<i>m-tape</i>	
O	6.590	6.650	<i>6.625</i>	✓			
P	0.940	0.980	<i>0.960</i>	✓			
Q	18.97	19.03	<i>19.00</i>	✓		<i>m-tape</i>	
R	0.350	0.410	<i>0.382</i>	✓			
S	0.740	0.780	<i>0.760</i>	✓			
T	0.240	0.280	<i>0.256</i>	✓			
U	0.370	0.410	<i>0.378</i>	✓			
V	0.740	0.780	<i>0.751</i>	✓			
W	0.740	0.780	<i>0.760</i>	✓			

Measured by: <i>JL</i>	Audited by: <i>D.A</i>	Prototype Approval:	N/A
Date: <i>10/11/17</i>	Date: <i>10/11/23</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D205-564-011 & D430-688-011	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	
C	06.08.31	Dimensions updated per D2521 Rev. J	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

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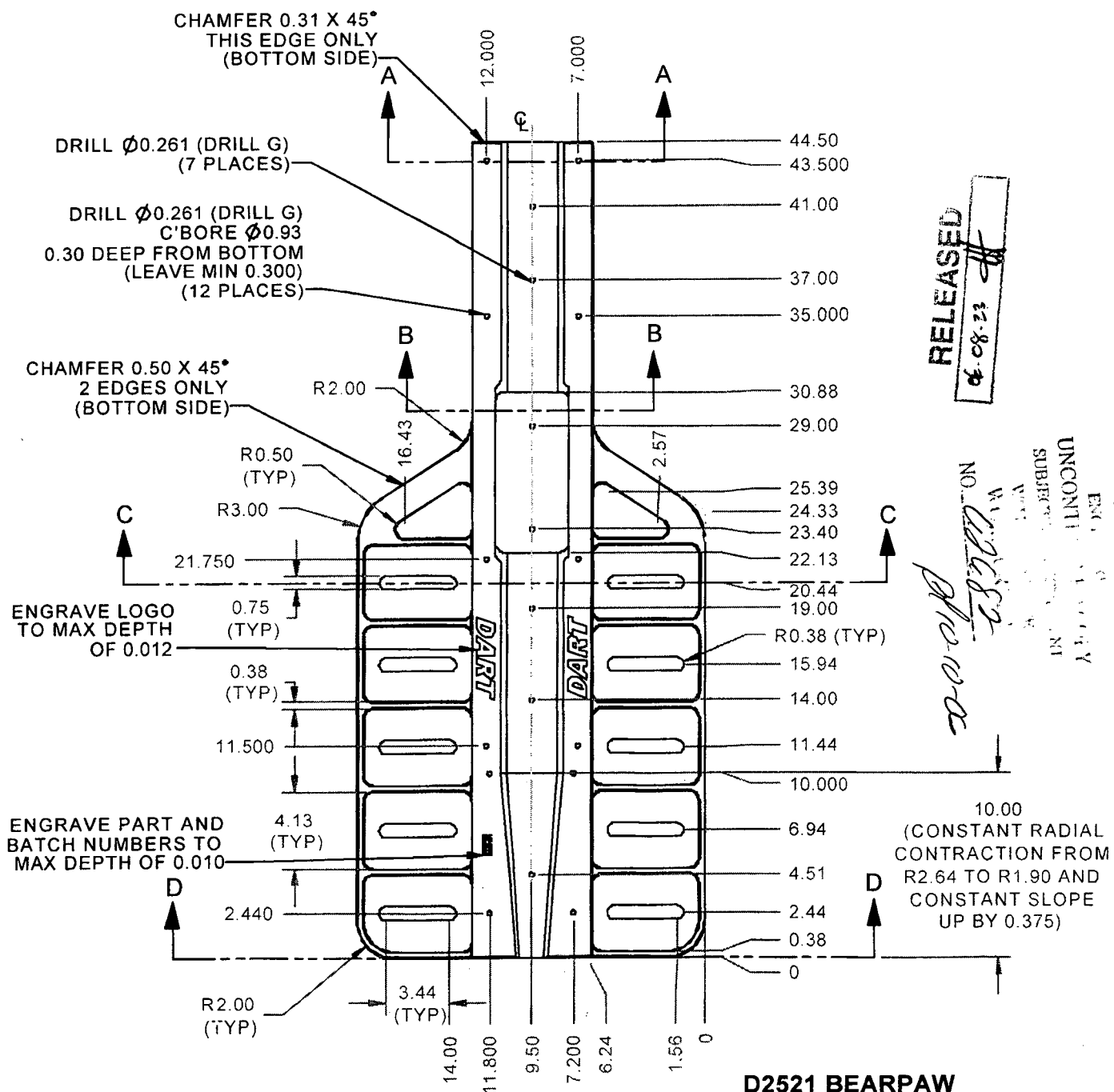
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
	C.B.	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. J
UP		D2521	SHEET 2 OF 3
DATE		TITLE	SCALE
06.07.28		205 BEARPAW	1:8

**NOTES:**

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.030
- 6) PART IS SYMMETRIC ABOUT \varnothing

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DESIGN	<i>#</i>	DRAWN BY	<i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>CP</i>	APPROVED	<i>#</i>	DRAWING NO.	REV. J
				D2521	SHEET 1 OF 3
DATE	06.07.28			TITLE	SCALE
				205 BEARPAW	NTS
A	95.11.28	NEW ISSUE			
B	96.01.11	SHOW BENDING MOVE HOLES			
C	96.01.29	ADJUST HOLE LOCATION FOR TOOLING			
D	96.05.14	ADJUSTED BEAR PAW THICKNESS			
E	96.12.18	43.500 WAS 46.750			
F	97.05.07	ADDED REAR POCKET, MOVED HOLES			
G	98.08.06	ADD C'BORE AND CHAMFER EDGES			
H	03.01.30	CHANGE GEOMETRY FOR RUN-ON LDG.			
I	05.05.20	REMOVE BEND; CHANGE TOLERANCES			
J	06.07.28	CHANGE FOR FLOAT SKIDTUBE			

W642682

RELEASED

06 08.23 *#*

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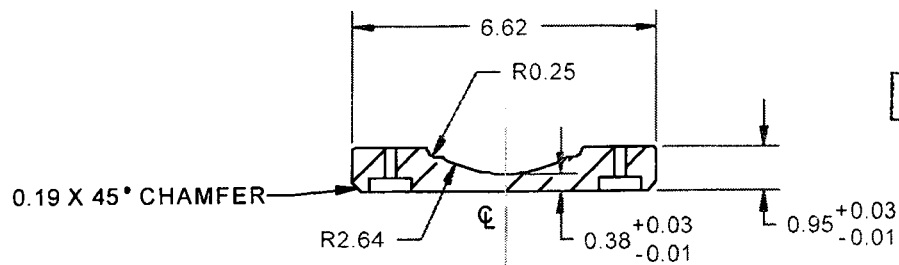
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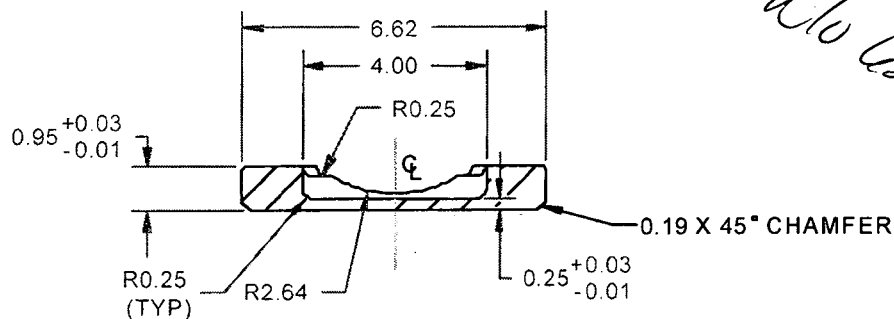
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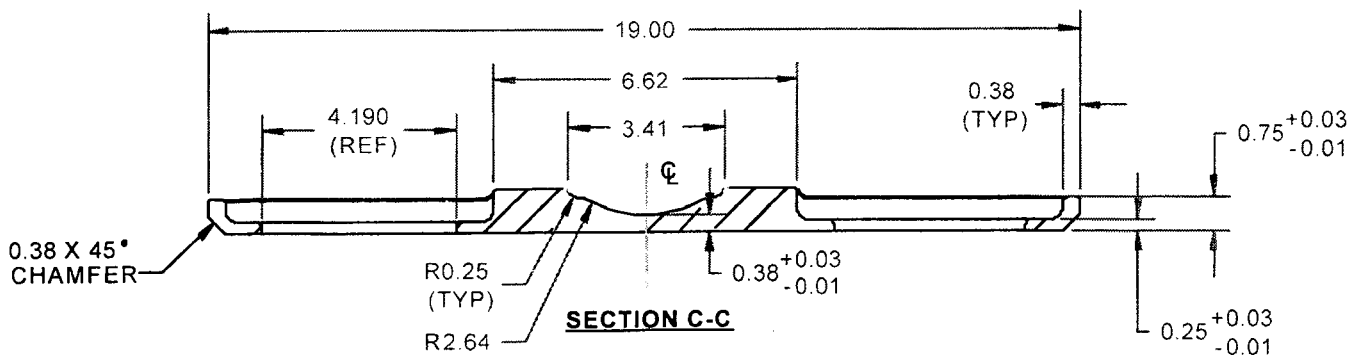
DESIGN #	DRAWN BY C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED [Signature]	DRAWING NO. D2521	REV. J SHEET 3 OF 3
DATE 06.07.28	TITLE 205 BEARPAW	SCALE 1:4	



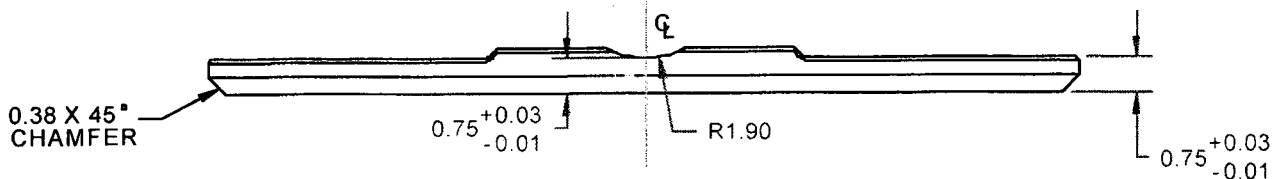
SECTION A-A



SECTION B-B



SECTION C-C



SECTION D-D

RELEASED

06.08.23 [Signature]

W6 62482

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